

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-001485**Date Inspected:** 25-Feb-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 600**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Cui Yi Ru**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector Tim McClendon arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China to periodically monitor welding and Quality Control (QC) functions. While on site the QA Inspector observed and/or discovered the following.

Caltrans QA Inspector McClendon monitored Flux Cored Arc Welding of the OBG Floor Beam FB004-001 Flange Welds. ZPMC welder Mr. Hong Yong Li Certification Number 044801 and MR. Zhang Qing Quan Certification Number 044774 appeared to be welding in accordance with WPS-B-T-2132-3 and AWS D1.5 (2002) requirements. The following welding variables were recorded, amperage 297, voltage 29 Travel Speed 451mm/min for Mr. Youg and amperage 298, voltage 29 Travel Speed 446mm/min for Mr. Quan. ZPMC Certified Welding Inspector (CWI) Cui Yi Ru Certification number 00072221 and ZPMC Quality Control (QC) Guo Yangwei were observed monitoring and recording welding variables.

Caltrans QA Inspector McClendon observed the fitting of various stiffeners to FB022-01, FB021-02, FB025-01. ZPMC is attempting to remove zinc primer coating with a sanding disk. 100% removal is not being accomplished, the sanding disk does leave the surface smooth and free of primer, but the blast profile - (indentation's made during the blast process) is unaffected.

Summary of Conversations:

No relevant conversations spoken on this date.

Comments

WELDING INSPECTION REPORT

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This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By:	McClendon, Timothy	Quality Assurance Inspector
Reviewed By:	Cuellar, Robert	QA Reviewer
